

chip off log

Process Sheet

split SB 07/09/04

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM	
Job Number	: 34287		Part Number	: D2065	
Estimate Number	: 11969		Drawing Number	: D2065 REV B1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 28/08/2007 S.O. No. : N/A		Drawing Revision	: B1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 04/09/2007	
Previous Run	: N/A		Qty:	10	
Written By			Um:	Each	
Checked & Approved By					
Comment	: Est: E 02.04.15 Added Dwg Rev.B1NG				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 1.7063 f(s)/Unit Total: 6.8250 f(s) 304 RD Tube .500 x .035W Seamless Tube (Ref. QSI 017 4.1.1.2) as per Dwg D2065 using DT8012. Note: 1 end only Batch: M105354	FF 06-08-31
2.0	BAND SAW	BAND SAW	 (PT) →
		Comment: BAND SAW Punch 1/2" OD x .035" Wall 304/316 SS Cut to length as per Dwg D2065 Form as per Dwg D2065 and template DT8251 Drill 0.188" Dia holes as per Dwg D2065 and template DT8251 Deburr	FF 06-08-31 FF 06-08-05
3.0	QC5	INSPECT WORK TO CURRENT STEP	 E 07/09/10 (x9)
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	POWDER COATING	POWDER COATING	 M102316 M 07-08-12 (9)
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/04	2	Split Up			SB	07/09/05 9			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07/09/05	20	if parts, the end holes are at 0.58" instead of 0.64". Human error. R.C: Do not bottom out all the way on the 1/4"; bend is too short, slightly.	QS1412	parts acceptable.	N/A	1/409-10	1/409-12	1/409-20	

NOTE: Date & initial all entries

Date: Tuesday, 28/08/2007 1:49:05 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34287

Part Number: D2065

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



m 07 09 12



⑨

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



1/9/12



⑨x SP

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

7.0 QC21

FINAL INSPECTION/W/O RELEASE

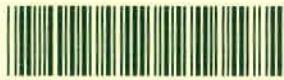


⑨

Comment: FINAL INSPECTION/W/O RELEASE

D 09/09/12

Job Completion



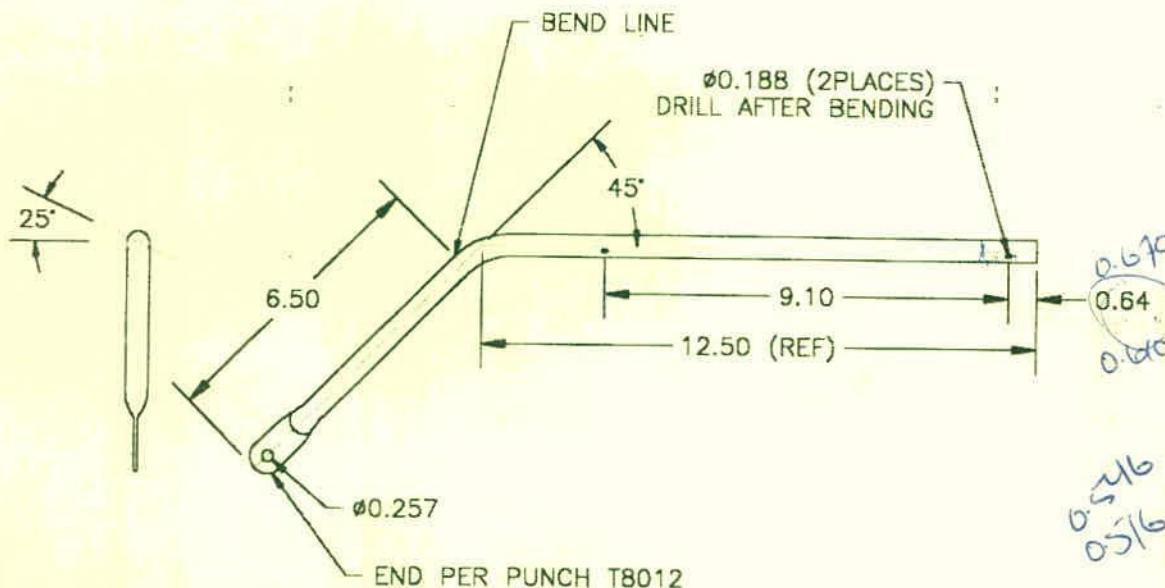
il 07/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2065 CUT LENGTH 19.5

MATERIAL: 304/316 SS 1/2 OD X 0.035 WALL
 FINISH: POWDER COAT BLACK SANTEX (475°F) PER
 DART QSI CUT 4.3 139

RELEASED
 9/4/94 BY

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
B. WILLIAMS	B. WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>B. Williams</i>	<i>D. Williams</i>	D2065
DATE	REV.	SCALE
92.03.12	B	1:4
TITLE		
ARM	RE-DESIGN	
	02.03.25	
	AUD FMS/H	

0.⁶
0.46
- 0.84
.652